

Work Order ID 66301

Wednesday, February 09, 2011 1:23:41 PM



Page 1

Item ID: D412-742-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 2/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: WLF

Date: 1-02-09

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-742	D								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013 CHG006

S. Schultz

H. J. BG 11-4-27

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/27

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S. Schultz

Y 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Start Date: 2/10/2011 Start Qty: 1.00

Required Date: 2/22/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location: _____								
		REN H							
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11-09-29
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation



Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A 05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP RevF: add
 AN4C7A DD 10.01.13 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4C7A		Purchased	No			110	Each	448.0000	4	4			
Bolt													

Location	Loc Qty	Loc Code
ST356	448	
109147	448	

-D412-742-043		Manufactured	No			110	Each	0.0000	1	1			
Replacement Float Skidtube													

D2571		Manufactured	No			110	Each	23.0000	1	1			
Saddle, Fwd Out 205													

Location	Loc Qty	Loc Code
ST425	3	
43564	3	
ST433	20	
62111	8	
63499	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

D2572

Manufactured No

110

Each

20.0000

1

1



Saddle, Fwd In 205



B63

Location

Loc Qty

Loc Code

ST425

3

43565

3

ST433

17

62150

5

63500

12

D2573

Manufactured No

110

Each

20.0000

1

1



Saddle, Aft Out 205



B635018

Location

Loc Qty

Loc Code

ST425

3

43566

3

ST434

17

62151

5

63501

12

D2574

Manufactured No

110

Each

21.0000

1

1



Saddle, Aft In 205



11/4/27

Location

Loc Qty

Loc Code

ST425

3

43567

3

63502

12

ST434

18

62152

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

D2876
Saddle Spacer

Manufactured No

110 Each

83.0000

2 : 2

Location

Loc Qty

Loc Code

ST026

83

60853

36

63326

47

D2877
Saddle Spacer

Manufactured No

110 Each

93.0000

2 2

Location

Loc Qty

Loc Code

ST026

93

60854

4

61211

41

63325

48

D3403-1
Bushings

Manufactured No

110 Each

110.0000

16 16

Location

Loc Qty

Loc Code

ST052

110

61654

9

63316

60

64773

41

D2747
Set Screw

Manufactured No

110 Each

209.0000

4 4

Location

Loc Qty

Loc Code

ST023

209

39224

4

59879

5

62085

100

64276

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3533-1

Manufactured No

110 Each

21.0000

2



Set Screw



2
B661385

Location

Loc Qty

Loc Code

ST069

21

51602

21

Purchased

No

110 Each

359.0000

16

AN4C6A



Bolt



16

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

255

113121

1

115016

16

116003

188

116400

50

ST358

100

116704

100

Purchased

No

110 Each

112.0000

8

AN4C52A



BOLT



8
1141238

Location

Loc Qty

Loc Code

ST361

112

112641

50

113121

12

114784

50

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C12A
BOLT

Purchased No

110 Each

70.0000 8

Location

Loc Qty

Loc Code

ST342

70

114442

40

116022

30

D3672-3
Phenolic Washer

Manufactured No

110 Each

914.0000 32

Location

Loc Qty

Loc Code

ST077

914

64176

914

AN960C416L
WASHER

Purchased No

110 Each

19.0000 32

Location

Loc Qty

Loc Code

ST346

19

112828

19

D3672-9
Phenolic Washer

Manufactured No

110 Each

382.0000 8

Location

Loc Qty

Loc Code

ST077

382

35523

382

AN960C616L
WASHER

Purchased No

110 Each

148.0000 8

Location

Loc Qty

Loc Code

ST347

148

113064

148

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-11

Manufactured No

110 Each

780.0000 16



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

780

58046

780

MS21043-4

Purchased No

110 Each

1,029.000 29



Nut

Location

Loc Qty

Loc Code

ST301

1029

114523

5

114784

2

115936

126

116188

596

116549

300

D3403-3

Manufactured No

110 Each

60.0000 8



Bushing

Location

Loc Qty

Loc Code

ST053

50

59598

9

62240

21

63323

20

ST055

10

56857

10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3405-041

Manufactured No

110 Each

34.0000

1

1



Lug Assembly



SP

Location

Loc Qty

Loc Code

ST474

34

60495

3

61995

5

62227

12

62958

14

1

D3405-043

Manufactured No

110 Each

29.0000

1

1



Lug Assembly



67920

Location

Loc Qty

Loc Code

ST474

29

53888

1

56514

1

60205

2

61675

10

62959

15

114278

AN4C47A

Purchased No

110 Each

114.0000

4

4



Bolt



114278

Location

Loc Qty

Loc Code

ST361

114

115231

7

115518

32

115936

30

116003

20

116400

25

2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

110 Each

26.0000

1

1



Tow Ring



68745

Location

Loc Qty

Loc Code

ST464

26

61219

4

62228

10

62960

12

D3417-3

Manufactured No

110 Each

106.0000

2

2



Washer



11/4/2011

Location

Loc Qty

Loc Code

ST056

106

44349

25

51648

28

53182

53

2

D3456-1

Manufactured No

110 Each

88.0000

1

1



Washer



B68748

Location

Loc Qty

Loc Code

ST058

88

63239

3

64282

85

AN3C37A

Purchased No

110 Each

8.0000

1

1



BOLT



11/7/313 11/4/2011

Location

Loc Qty

Loc Code

ST353

1

114801

1

ST354

7

116381

7

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C40A

Purchased No

110 Each

111.0000

1

BOLT

Location

Loc Qty

Loc Code

ST354

111

106176

11

~~112454~~

50

114442

50

AN3C41A

Purchased No

110 Each

59.0000

1

BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

55

116381

55

AN3C42A

Purchased No

110 Each

68.0000

1

BOLT

Location

Loc Qty

Loc Code

ST354

68

106176

68

AN3C43A

Purchased No

110 Each

85.0000

4

BOLT

Location

Loc Qty

Loc Code

ST354

85

114330

5

114433

30

114455

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Wednesday, February 09, 2011 1:24:59 PM

Work Order ID: 66301

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 2/10/2011

Required Date: 2/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

66.0000

5

5



BOLT

Location

Loc Qty

Loc Code

ST355

66

113302

36

115030

10

115518

20

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

25.0000

26

26



washer

Location

Loc Qty

Loc Code

ST245

25

107534

25

MS21043-3

Purchased

No

110

Each

1,394.000

13

13



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1318

112314

1318

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D412-742

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Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D
Date: 07.10.04

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

REFERENCE 8

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
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WAS:

63	4			AN4C46A	BOLT
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5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4		AN4C47A	BOLT
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WAS:

63	4		AN4C46A	BOLT
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A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
DATE	08.12.19	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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